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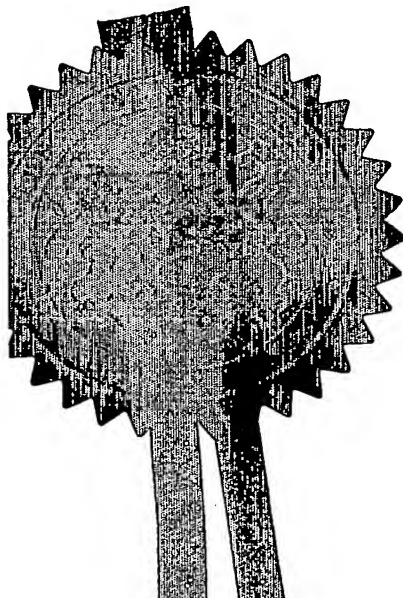
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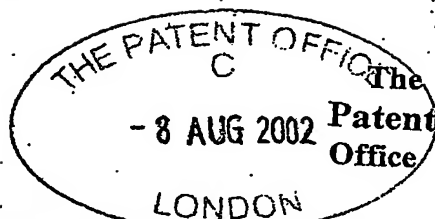


R. Mahoney

Signed

Dated 28 August 2003

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Request for grant of a patent

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No Fee

The Patent Office
Cardiff Road
Newport
Gwent NP10 8QQ

1. Your reference

RA/P301604GB

2. Patent application number
(The Patent Office will fill in this part)

0218420.8

- 8 AUG 2002

3. Full name, address and postcode of the or of each applicant (underline all surnames)

Supreme Plastics Holdings Ltd
Supreme House
300 Regents Park Road
Finchley
London N3 2TL

Patents ADP number (if you know it)

8180622001

If the applicant is a corporate body, give the country/state of its incorporation

United Kingdom

4. Title of the invention

Reclosable bag production

5. Name of your agent (if you have one)

W. P. Thompson & Co.

"Address for service" in the United Kingdom to which all correspondence should be sent (including the postcode)

Eastcheap House, Central Approach
Letchworth
Herts SG6 3DS

Patents ADP number (if you know it)

158003

6. If you are declaring priority from one or more earlier patent applications, give the country and the date of filing of the or of each of these earlier applications and (if you know it) the or each application number

Country	Priority application number (if you know it)	Date of filing (Day/month/year)
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7. If this application is divided or otherwise derived from an earlier UK application, give the number and the filing date of the earlier application

Number of earlier application	Date of filing (Day/month/year)
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8. Is a statement of inventorship and of right to grant of a patent required in support of this request? (Answer 'yes' if:
a) any applicant named in part 3 is not an inventor, or
b) there is an inventor who is not named as an applicant, or
c) any named applicant is a corporate body.
See note (d))

Yes

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Continuation sheets of this form

Description 7

Claims

Abstract

Drawing(s) 1

10. If you are also filing any of the following, state how many against each item.

Priority documents

Translations of priority documents

Statement of inventorship and right to grant of a patent (*Patents Form 7/77*)

Request for preliminary examination and search (*Patents Form 9/77*)

Request for substantive examination (*Patents Form 10/77*)

Any other documents
(Please specify)

11. We request the grant of a patent on the basis of this application

Signature

Date

7 August 2002

W. P. Thompson & Co.

12. Name and daytime telephone number of person to contact in the United Kingdom Dr Robert Ackroyd
01462 682139

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Notes

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RECLOSABLE BAG PRODUCTION

This invention relates to the production of reclosable bags which have a reclosable seal formed by releasable and
5 engagable zipper strips attached to opposed walls of the bag.

The reclosable seal is often provided adjacent a non-reclosable seal, for example a heat seal, and allows the bag to be reclosed when the non-reclosable seal has been
10 opened. Such bags are often formed by use of a horizontal or a vertical form-fill-seal machine.

In preparing continuous web material for supply to a form-fill-seal machine, or other apparatus for forming bags having reclosable seals, a continuous length of web
15 material from which the bags are to be formed is advanced in a longitudinal direction and separate lengths of zipper strip are applied to the web so that they are at spaced intervals longitudinally of the web and extend transversely (usually perpendicularly) to the longitudinal direction.
20 Each zipper strip length comprises first and second interengagable profiles which are pre-assembled into at least partial engagement with each other. This is known as "cross-web technology": see our published UK patent application GB-A-2349603 which describes a form-fill-seal
25 machine using that technology. Figure 5 of GB-A-2349603 shows the use of a pair of spring-loaded zipper sealing jaws which operate to seal the zipper strips to the walls of the bag simultaneously with formation of the non-reclosable end seal of the bag. This operation requires a
30 certain time as it is necessary for the zipper sealing jaws to supply heat to the zipper strips to seal them to the bag walls. The step therefore slows down the entire form-fill-seal operation.

According to the present invention, there is provided
35 a method of making a reclosable bag, comprising the steps of:

supplying a continuous web of bag-forming material in a first direction to a bag-forming station;

attaching to the continuous web a plurality of zipper strips at intervals spaced in the first direction and extending transversely of the web, each zipper strip comprising first and second interengagable profiles pre-assembled into at least partial engagement with each other;

forming end-sealed bags at the bag-forming station, each bag having opposed first and second walls, at least one of which is formed from the said continuous web of material, first and second end seals, and therebetween at least one of the zipper strips attached to a respective wall of the bag; and

treating the bags adjacent the respective zipper strip profiles in order to secure the profiles to the first and second walls respectively and to form an openable and reclosable seal inside the bags.

In a method according to the present invention, the respective zipper strip profiles are not finally attached to the bag walls until after the bag has been formed.

In a preferred form of the invention, the zipper strips are initially attached to the continuous web only sufficiently to hold them in position: final securement takes place only after formation of the bag.

The step of treatment of the walls of the bag to secure the zipper profiles may take place before or after the web has been separated into individual bags but preferably takes place after separation of the continuous web into individual bags.

Initial attachment and/or securement of the zipper strip profiles to the bag walls can be by means of pressure-sensitive or heat-sensitive adhesive, by fusing of the material of the bags and/or the strips under the application of heat and/or pressure, or by any other suitable means. The means for initial attachment and for subsequent securement may be the same or different.

Separation of the continuous web into individual bags prior to the securement of the zipper strips to the bag walls allows securement to take place at a securement station prior to which the bags are reorientated so that

they are fed to the securement station with their zipper strips aligned along a common axis.

The common axis may be parallel to the direction of supply of the continuous web but is preferably transverse
5 to that direction, most preferably perpendicular thereto.

The invention also provides an apparatus for making a reclosable bag, the apparatus comprising successively:

means for supplying a continuous web of bag-forming material in a first direction:

10 means for attaching to the continuous web a plurality of zipper strips at intervals spaced in the first direction and extending transversely of the web, each zipper strip comprising first and second interengagable profiles pre-assembled into at least partial engagement with each other;

15 a bag-forming station at which are formed bags having opposed first and second walls, at least one of which is formed from the continuous web of material, first and second end seals and therebetween and attached to a respective wall of the bag at least one of the zipper
20 strips; and

means for treating the bags adjacent the respective zipper strip profiles to secure the profiles to the first and second walls respectively and to form an openable and reclosable seal inside the bags.

25 Preferably, the apparatus comprises means located between the bag-forming station and the securement means for separating the continuous web into individual bags.

Advantageously, the apparatus comprises means located between the separating means and the securement means for
30 reorientating the separated bags so that their respective zipper strips are aligned one with another along a common axis.

The securement means preferably comprises means for conveying the bags through a treatment zone, where the bags
35 are treated with heat and/or pressure, or otherwise, to secure the zipper-strip profiles to the walls of the bags.

The conveying means advantageously engage the zipper-strip profiles, whilst making contact with the respective outer surfaces of the walls of the bags.

Preferably, the conveying means also effect the
5 treatment to secure the profiles to the bag walls. Conveniently, this is achieved by application of heat and/or pressure by way of the conveying means, for example by the conveying means comprising a belt sealer.

In the present invention, separation of the individual
10 bags and reorientation of the bags before securement of the zipper strips allows the rate of bag production to be high because the zipper strips can be secured in a shorter time period than could be achieved by securement whilst the bags still formed a continuous web.

15 An embodiment of the invention will now be described by way of example with reference to the drawing of this specification, in which:

Figure 1 is a somewhat schematic drawing of a
horizontal form-fill-seal apparatus using cross-web
20 technology;

Figure 2 is a longitudinal sectional view of a bag at an intermediate stage in the production of bags using the apparatus of figure 1, the bag being as at the stage indicated by the letter "B" in figure 1; and

25 Figure 3 is a view similar to figure 2 but showing the finished bag, as at the stage indicated by the letter "C" in figure 1.

Referring to figure 1, this shows a storage roll 10 of web material 12, for example polyethylene. The web
30 material 12 is advanced from the roll 10 past a cross-web applicator 14 at which lengths of zipper 16 are attached to the web at spaced intervals in the direction of advancement of the web, shown by the arrow "X" in figure 1. The cross-web applicator is preferably as described in our copending
35 UK Patent Application 0211573.1 but any suitable apparatus may be used, for example that described in GB-A-2349603 referred to above.

Each length of zipper consists of a first and a second interengagable profile, which are respectively "male" and "female" in cross-sectional shape. Each profile has a respective surface for attachment to the web material. An example of suitable zipper profiles can be seen in our published international patent application WO-A-02/06040. The attachment surfaces extend in spaced parallel planes when the profiles are in engagement with each other. As seen in figure 1, the lengths of zipper 16 are attached to the web 12 by the formation of a tack seal between the flange of one zipper profile and the web material 12. Each length of zipper 16 is approximately one-half the width of the web material 12. The lengths are positioned approximately mid-way between the longitudinal edges of the web material.

After application of the lengths of zipper 16, the web material 12 is formed into a tubular shape by the form-fill-seal apparatus. This is shown only schematically in figure 1. In this operation, the longitudinal edges of the web material 12 are brought together to form a back seal 18 which is made by the action of heated clamping bars (not shown). Similarly, transverse end seals 20 are formed by the action of further heated clamping bars 22. During this operation, product is introduced into the bags being formed. The means for doing this are not shown in figure 1 but they are well-known in the field of form-fill-seal apparatus. Formation of the back seal 18 and the end seals 20 produces a continuous length of bags which is then cut into separate individual bags 24 by cutting means (again not shown but well-known in the field of form-fill-seal apparatus).

An individual bag as first produced is shown by the letter "B" in figure 1 and in longitudinal section in figure 2.

Figure 2 shows the bag to have an end seal 20 at each end and a length of zipper 16 tack-sealed to one wall of the bag inside the bag and adjacent one of the end seals 20. The tack-seal of the length of zipper 16 to the

material of the bag is between the attachment surface of one zipper profile and the bag. The other zipper profile is engaged with the first zipper profile, at least to the extent necessary to hold the profiles in the correct alignment for their engagement. Normally, the profiles will be fully engaged.

After the continuous length of bags has been cut into individual bags 24, the bags are moved laterally from the direction of advancement of the web 12, shown by the arrow "X" in figure 1, into a line perpendicular thereto and shown by the arrow "Y" in figure 1.

After lateral movement of the bags 24 into the direction of the arrow "Y" the bags are engaged by a belt sealer comprising a pair of heated gripping guides 26. One of the guides 26 engages the outer surface of the bag 24 immediately adjacent the respective zipper profile which is tack-sealed to the inner surface of the bag. The relatively stiff zipper profile facilitates this engagement between the respective guide 28 and the bag. At the same time, the other guide 26 engages the other zipper profile through the material of the bag.

The engagement of the guides 26 with the zipper 16 through the material of the bag not only allows the bags to be conveyed further in the direction of arrow "Y" but also effects complete sealing of the zipper profiles to the respective inner surfaces of the walls of the bag. This complete sealing can be brought about by heat or pressure, or by both, or by any other suitable means. At the same time, the zipper profiles are, if not already, brought into complete engagement with each other.

The final bag 28 is shown by the letter "C" in figure 1 and in longitudinal section in figure 3. It will be seen from figure 3 that the final bag has non-reclosable end seals 20 and a reclosable seal formed by the zipper 16 inside the bag. This allows the bag to be resealed by means of the zipper 16 after it has been opened by opening the non-reclosable end seal 20 adjacent the zipper 16.

It will be noted that, in the bag production method of the invention, the sealed bag (as in figure 2) is first formed with the zipper attached to only one wall thereof. The zipper is attached to the other wall after formation of
5 the sealed bag.

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